

Date: Tuesday, 15/07/2008 9:15:35 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 40494		Part Number	: D30413		
Estimate Number	: 10351		Drawing Number	: D3041 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 15/07/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: MACHINED PARTS			
Previous Run	: 35979		Due Date	: 15/08/2008		Qty: 40 Um: Each
Written By	:					
Checked & Approved By	: STUO 08.15.08					
Comment	: Est:A 01.07.11 New Issue SM/EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
		Comment: Qty.: 0.1094 f(s)/Unit Total : 4.3764 f(s) Lug Extrusion (D2423) Batch: B333/0
2.0	BAND SAW	BAND SAW
		 cut @ meter
		Comment: BAND SAW Cut D2423 Extrusion: 1.250" Long
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 use p/b 6778 meter Comment: HAAS CNC VERTICAL MACHINING #1 Check for cracks while loading into the machine Machine as per Folio FA153 and Dwg D3041 Tumble and Deburr rough edges after tumbling Identify as D3041-3 <i>unmachine as per drawing D3041 REV C.</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 read + inspect for transit damage. ensure cuffs attached Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC3	SECOND CHECK
		 S Comment: SECOND CHECK <i>Inspect Level S</i> 05/08/11 X40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		08-08-12
7.0	POWDER COATING	POWDER COATING M108523
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 Mask inside of 0.8120" diameter hole		START TIME: <u>10:20</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>10:50</u> m/1 08/08/13
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	D2611	Bearing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Bearing Pick: Qty Part Number Description Batch		08-08-13 <u>B40510</u> FF
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Press D2611 bearing into lug as per Dwg D3041 2- Stake bearing into place as per Dwg D3041 3-Touch up stake marks with white emeron paint		08-08-14 FF 08-08-18
11.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 465

AS 08/08/19 (RC)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/20 AS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



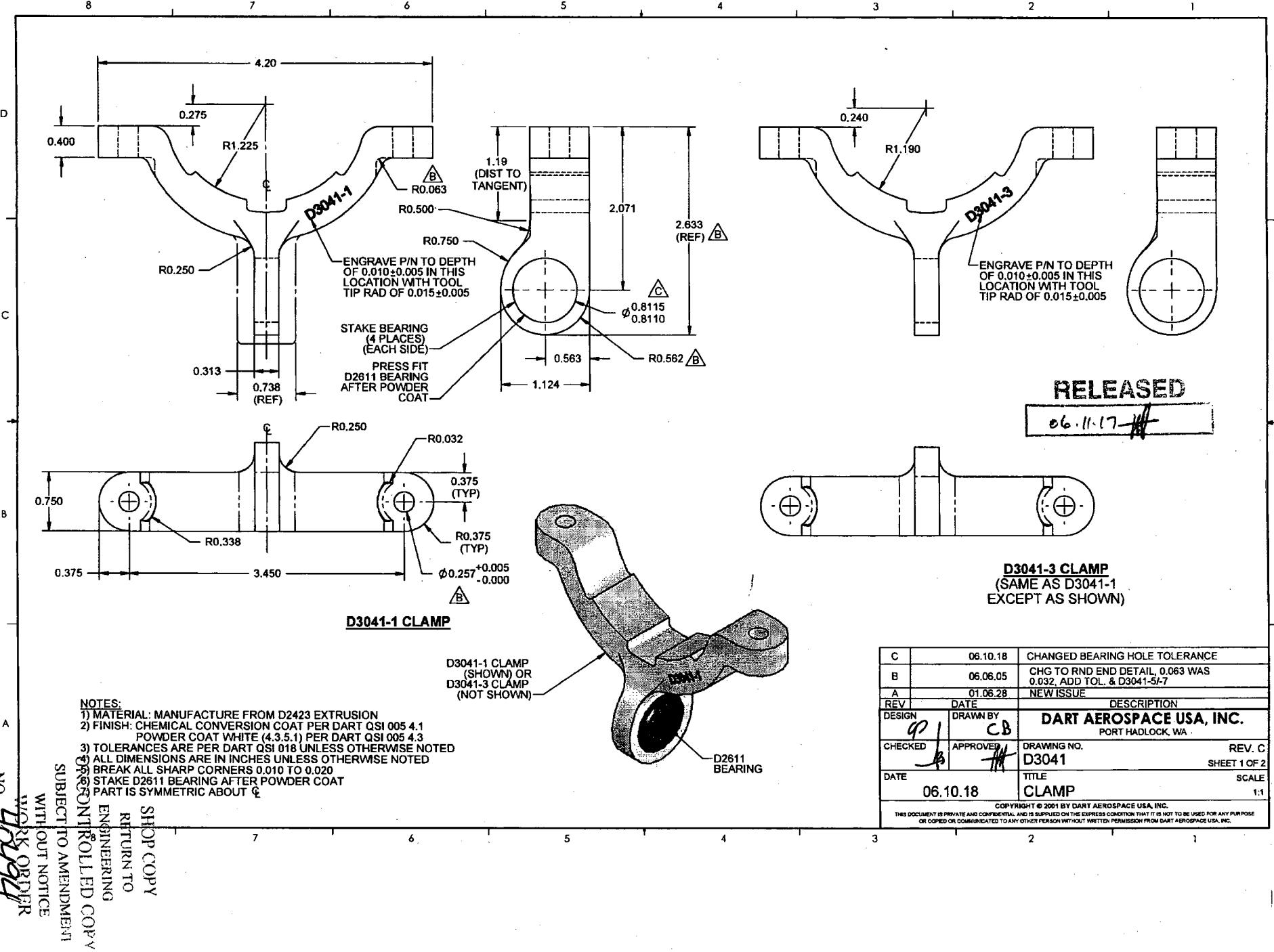
MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

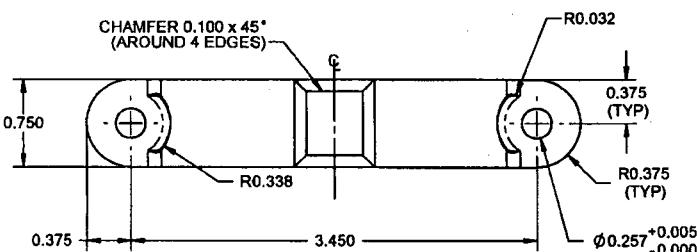
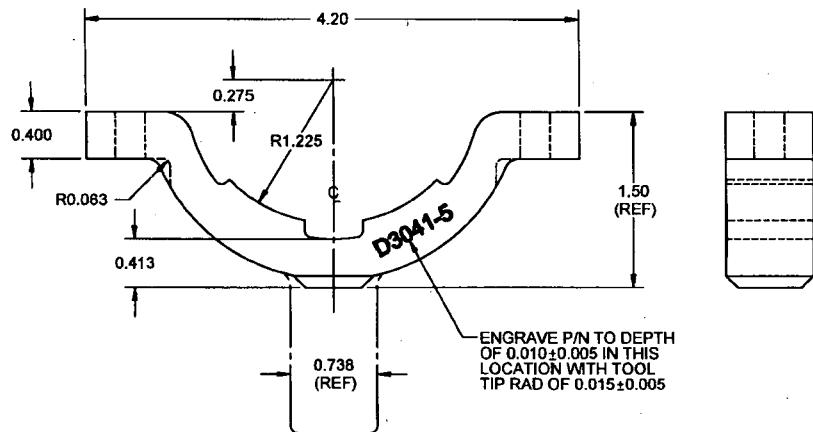
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

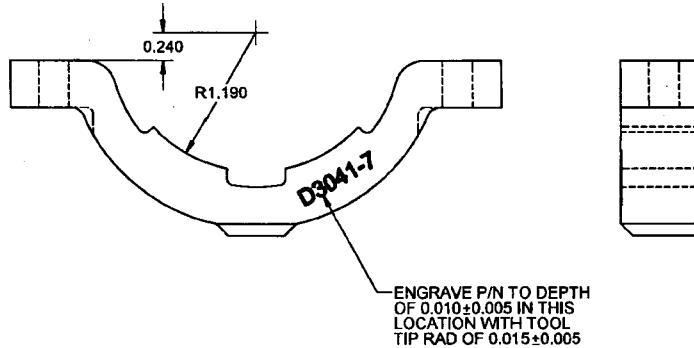
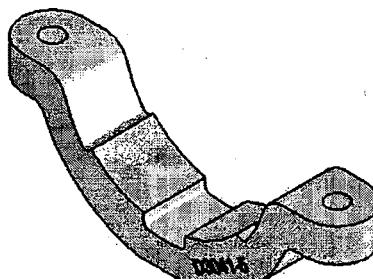


RELEASED

06.11.17 *H*



D3041-5 CLAMP *A*



D3041-7 CLAMP
(SAME AS D3041-5) *B*

- NOTES:
1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
6) PART IS SYMMETRIC ABOUT *C*

DESIGN <i>g1</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>b</i>	APPROVED <i>H</i>	DRAWING NO. D3041	REV. C	SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP	SCALE 1:1		

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3041-1	Lug B40493	6776
40	D3041-3	Lug B40494	6776

MATERIAL supplied by DART D2423 B33310

S
Shig
Walz

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz".
Shigi Walz

Vankleek Hill, August 8, 2008